

## ABSTRACT

A machine cell for the forming and joining of a first sheet material to a second sheet material includes an upper gate and a lower nest. The lower nest includes a vacuum pad having a recessed channel defined therein. A vacuum system is fluidly connected to the recessed channel to hold the first sheet material to the lower nest during the joining of the first and second sheet materials. The machine cell further includes an arrangement for aligning the first sheet material to the second sheet material.

BLOOMFIELD 46717-6 660802